

Dunde Silver

# Work Order ID 51856



Page 1

Tuesday, September 08, 2009 8:40:31 AM

Item ID: D206-628-013QS

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH-QUICK SILVER

Start Date: 9/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

150

0.00



SprayPaint

Memo

0.00

Spray Painting

PULL FROM STOCK

1 X D206-628-013 B 36963

CHG004

REMOVE FROM KIT ALL LUGS, D2731-3 / -7, D3394-041/-043, and arm  
D2845

SCUFF STEP AND ALL PARTS ABOVE TO RE-PAINT IMRON QUICK  
SILVER B 112614

APPLY IMRON CLEAR B 112632

MA 09 09 09

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

ZT 09-09-10

**DART**

Dart Aerospace Ltd.

1270 ABERDEEN ST  
HAWKESBURY ON CANADA K6A 1K7

TC APPROVAL # 09-89

TEL: 1-613-632-5200

P/N	D206-628-013	CHG	CHG004
DESC	Heli-Access-Step LH	STC	SH98-14
LOT	B36963	STC	SA00500SE
MODEL	Bell 206A/B	STC	

**Work Order ID 51856**

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Page 2

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170



HandFinish

Hand Finishing

Memo

RE-WING WALK B

0.00

0.00

BR 09-09-10

①

180



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

9/9/09/11

1 0

190



Packaging

Packaging

Memo

RETURN LUGS D2731-3 / -7, D3394-041/-043 AND ARM D2845 TO  
ORIGINAL KIT

0.00

0.00

2ed F

9/9/14 (ix) SV

**Work Order ID 51856**

Tuesday, September 08, 2009 8:40:31 AM

Page 3

Item ID: D206-628-013QS

Accept

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Revision ID:

Stop

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Start Date: 9/4/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

QC4- 100% Inspect kits for completeness

0.00

27 8/9/09/14



QC

Memo

0.00

Quality Control

\*164 9

210

0.00



Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP USING NEW B/N  
NEW LABELS REQ'D 8/9/09/14

CHG 004

9/9/14 SD

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/14 JG

UMF  
09-09-14

# Picklist Print

Page 1

Tuesday, September 08, 2009 8:40:30 AM

Work Order ID: 51856



Parent Item: D206-628-013QS



Parent Item Name: Heli-Access-Step LH-QUICK SILVER

Start Date: 9/4/2009

Required Date: 9/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D206-628-013RevN/A		Manufactured	No				Each	5.0000	1.0000			



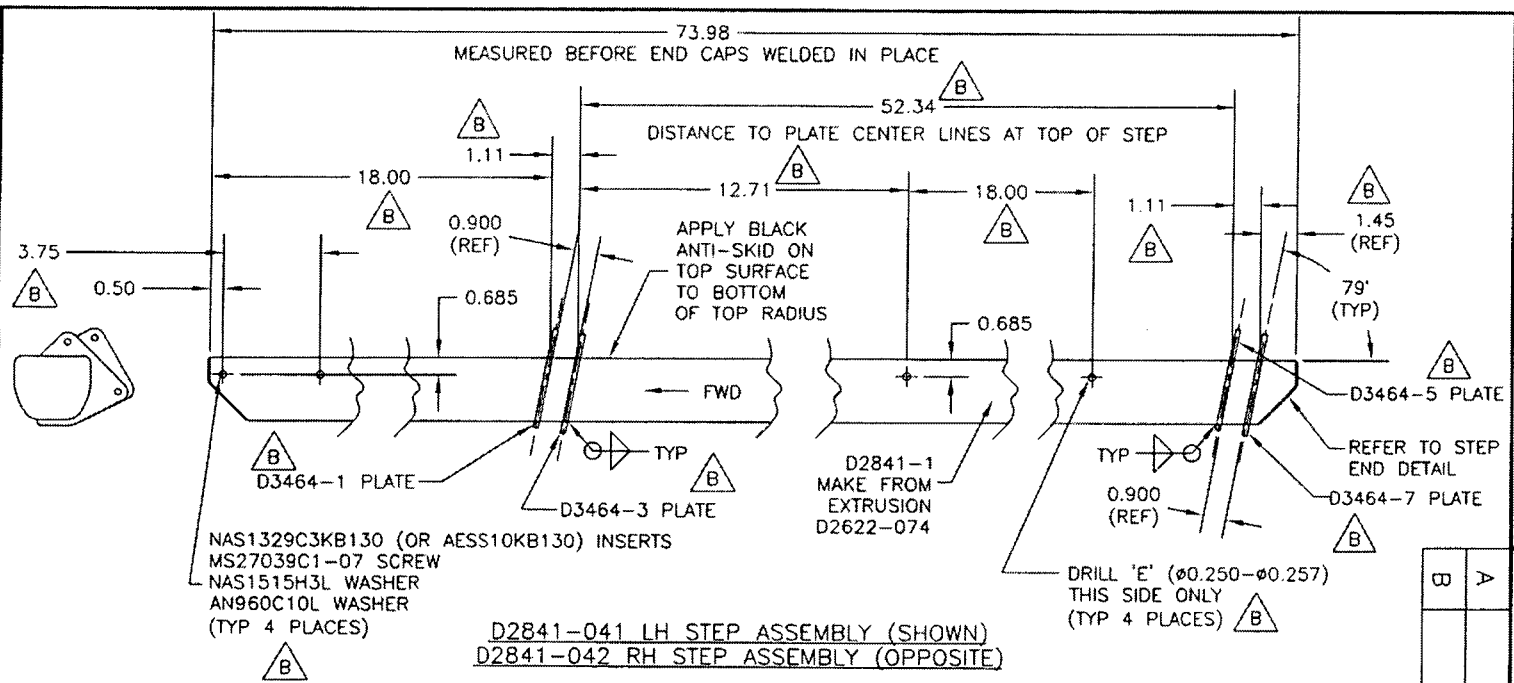
Heli-Access-Step LH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	2	
18942	1	
36078	1	
36963	3	

*mt 09/09/09*

W/B 5185

**DART**



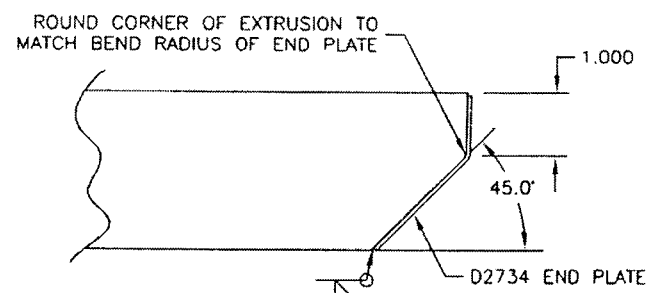
D2841-041 LH STEP ASSEMBLY (SHOWN)  
D2841-042 RH STEP ASSEMBLY (OPPOSITE)

**D2841-041/-042 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D2841-041	LH STEP ASSEMBLY
X	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

RELEASED  
05/11/14



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2841-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	05.09.21	TITLE	D2841	REV: B	
				SHEET 1 OF 1	
				SCALE	
				NTS	
				206B FLOAT STEP ASSEMBLY	
				NEW ISSUE	
				RE-DESIGN, ADD D2843-1/-3/-5/-7	

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Date: Monday, 04/02/2008 3:19:50 PM  
 User: Dominique Dube

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B FLOAT STEP ASSEMBLY
Job Number : 36963	
Estimate Number : 11785	
P.O. Number :	Part Number : D206628013
His Issue : 04/02/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 25/01/2008 Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 36078	Material :
Written By : <u>                    </u>	Due Date : 10/03/2008 Qty: 4 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM	

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-013 CHG 002

08.02.27                      per ECN 1118 4

2.0	36963A	206B FLOAT STEP ASSY, LH
-----	--------	--------------------------



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2841-041 B 36963 A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

UPDATED AS PER ECN 1118, D206-628-013 CHG NUM. 004

4.0	D27313	Mounting Lug
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-3 Mounting Lug

Batch

B37335

5.0	D27317	Mounting Lug
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-7 Mounting Lug

Batch

B3425

Date: Monday, 04/02/2008 3:19:51 PM  
User: Dominique Dube

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36963

Part Number: D206628013

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

6.0

D2845

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2845 ARM B 37339

AS 08/04/03

(X4)

7.0

D2732030

Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part # Description Batch

4 D2732-030 RUBBER CUSHION

ERROR

8.0

D2732030

Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) Total 32.

Pick:

Qty Part # Description Batch

4 D2732-030 RUBBER CUSHION

34717

AS 08/04/03

(X4)

9.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-041 LUG ASS,Y B34833 x2 B37345 x6

AS 08/04/03

(X4)

10.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-043 LUG ASS,Y B34834

AS 08/04/03

(X4)

11.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN3C4A Bolt M107376

AS 08/04/03

(X4)

Date: Monday, 04/02/2008 3:19:51 PM  
User: Dominique Dube

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36963

Part Number: D206628013

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

12.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M10785

JS 08/04/03 (x4)

13.0

AN4C14A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C14A

Bolt

M10787

JS 08/04/03 (x4)

14.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915 x 9 M107082 x 7

JS 08/04/03 (x4)

15.0

AN960C10

WASHER



Comment: Qty.: 2.0000 EACH(s)/Unit Total: 8.0000 EACH(s)

Pick:

M106302

JS 08/04/03 (x4)

16.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M107005 x 96

JS 08/04/03 (x4)

17.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M107008

JS 08/04/03 (x4)



Date: Friday, 1/25/2008 10:48:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36963

Part Number: D206628013

Job Number:



REFERENCE ONLY

Seq. #: Machine Or Operation: Description :

18.0 MS210434 Nut

5



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4 Nut (or MS21042-4) M107101

AS 08/04/03 (X)

19.0 NAS1515H3 Washer

5



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3 Washer M107101

AS 08/04/03 (X)

20.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/07 742H

21.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-013

Location: 36963A

PPP Rev: Rev A

AS 08/04/07 (X)

22.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09 (X)

Job Completion



MF 08-04-08

W

Date: Friday, 18/04/2008 7:50:09 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-628-UPDATE PAPERWORK  
 Job Number : 38685  
 Estimate Number : 10804  
 P.O. Number :  
 This Issue : 18/04/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : LARGE FAB ASSY  
 Previous Run : 00015  
 Written By :  
 Checked & Approved By :  
 Comment :

Part Number : Z\_CUSTOM  
 Drawing Number : ECN1126  
 Project Number :  
 Drawing Revision :  
 Material :  
 Due Date : 25/04/2008 Qty: 1 Um: Each

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :  
 1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

D206-628-011 33038 (3x) 33411 (3x)  
 D206-628-012 33892 (1x) 33412 (1x)  
 D206-628-013 36963 (4x) 36078 (1x)  
 D206-628-014 36964 (6x)  
 D206-628-021 31974 (1x) 34980 (1x) 35736 (2x)  
 D206-628-022 33757 (1x) 34991 (3x)  
 D206-628-023 36492 (1x) 34575 (2x)  
 D206-628-024 36493 (1x) 34576 (1x) (3x)  
 D206-628-031 31010 (1x)  
 D206-628-032 31011 (1x)  
 D206-628-033  
 D206-628-034

(36x)

ADD NEW PAPERWORK TO KITS IN STOCK  
 DSI 9332, PER ECN 1126

8/14/24 500